AMENDMENT NO. 1 DECEMBER 2016
TO
IS 15914 : 2011 HIGH TENSILE STRENGTH FLAT ROLLED STEEL PLATE (UPTO 6 mm), SHEET AND STRIP FOR THE MANUFACTURE OF WELDED GAS CYLINDER — SPECIFICATION

(*Page* 1, *clause* 1) — Substitute 'flat rolled' *for* 'hot rolled'.

(*Page* 1, *clause* **4.2**, *line* 1) — Substitute 'flat rolled' *fo*r 'hot rolled'.

(*Page* 1. *clause* **5.1**, *line* 2) — Substitute 'flat rolled' *for* 'hot rolled'.

(*Page* 2, *clause* **9**, Note) — Substitute 'flat rolled' *for* 'hot rolled'.

(*Page* 3, *Table* **3**) — Substitute the following for the existing table:

Table 3 Mechanical Properties

(*Clause* 7.1)

Sl No.	**Grade**	**Tensile Strength** Mpa	**Yield Stress** MPa *Min*	**Percent Elongation at Gauge Length** *Min*		**Reference Heat Treatment Austenitizing Temperature**
				< 3 mm (*see* Note 2)	3 to 6 mm (*see* Note 3)	
(1)	(2)	(3)	(4)	(5)	(6)	(7)
i)	HS 235	360-460	235	22	30	920-960
ii)	HS 265	410-510	265	20	28	890-930
iii)	HS 295	450-560	295	18	26	890-930
iv)	HS 345	490-610	345	17	24	880-920

NOTES

1 The above properties are specified for flat rolled steel and should meet the properties of normalized (Time at austenitizing temperature: approximately 2 min/mm of plate thickness) /stress relieved (Time at stress relieving temperature: as prescribed for Indian domestic cylinder) cylinders. Considering the drop in the normalizing, tensile properties of flat rolled products are to be mutually agreed upon between the cylinder manufacturers and steel producers for normalized cylinders.

2 Percentage elongation for products of thickness less than 3 mm, is calculated based on test pieces with a width of 20 mm and a gauge length of 80 mm.

3 Percentage elongation for products of thickness 3 to 6 mm, is calculated based on test pieces with a gauge length of $Lo = 5.65\sqrt{S_o}$ (S_o is the initial cross-sectional area of the test piece).

(*Page* 3, *clause* **11.1**, *sentence* **2**) — Delete.

(MTD 04)

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